

Work Order ID 76469

76469

November-15-11 8:11:31 AM

Page 1

Item ID: D3247-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Angle
 Start Date: 15/11/2011 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 29/11/2011 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: M.C.J. Date: 11/11/15 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3247	Rev A

100 0.00

100

Waterjet Memo 0.00

FLOW CNC Waterjet

1-Cut as per Dwg
 Dwg Rev: A
 Prog Rev: A

2-Deburr if necessary

12 03 27 (12)

110 0.00

110

QC Memo 0.00

Quality Control

QC2- Inspect parts off machine FAI/FAIB

12 03 27 (12)

Pro →

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D3247-1 PAR #: _____ Fault Category: SMALL PART / water jet NCR: Yes No DQA: Am Date: 12/04/09
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: CK Date: 12/4/11

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/04/09	#100	wrong mat. was used. operator picked 6061T6 + should have used 2024T3. RL LOA on operator.	S 12/04/09 051042	6061 is significantly weaker than 2024. SCRAP P12.04.03	12/04/03 FF FRANS.	U 12.04.02	S 12/04/09 051042	S 12/04/09
		it was only found when who was being checked.	MB 12/04/11 051042	Qty 12			MB 12/04/11 051042	

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		8/2/03/28		(+12)			
130 *130* Brake NC Brake NC	Bend as per dwg Memo	0.00 0.00		8/2/03/28		(12)			
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		8/2/03/28		(+12)			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.00							
Hand Finishing									
155	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
155									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 9h05 OVEN TEMP: 320°F FINISH TIME: 9h35								
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									

12XPM/12/03/29

12 Q (SP) 12/04/02.

M117338
M117338

12 12/12/2.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: _____	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

MLJ 12/04/03

12-04-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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November-15-11 8:11:36 AM

Work Order ID: 76469

76469

Parent Item: D3247-1

D3247-1

Parent Item Name: Angle

Start Date: 15/11/2011

Required Date: 29/11/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP B 04.10.26 D3247-1 no longer made in-house
10.12.06 NOW MADE IN HOUSE DD VERF:EC

IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	33.5000	0.2347	2.964632			
M2024T3S 063									**				
2024-T3 .063 sheet													

W 12-03-27

Location

Loc Qty

Loc Code

MAT022

33.5

117392

33.5

B#120866

used.
-M6061 T65.063
B 120866

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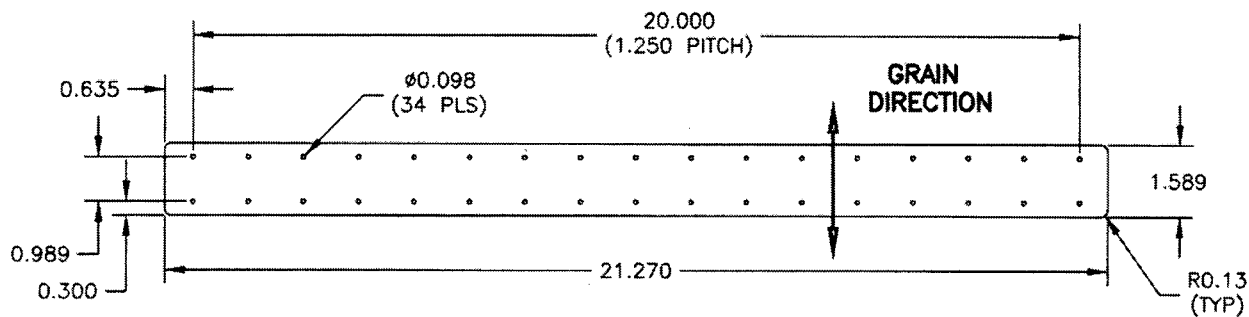


DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED #	DRAWING NO. D3247	REV. A SHEET 1 OF 1
DATE 04.04.06		TITLE ANGLE	SCALE 1:4
A	04.04.06	NEW ISSUE	

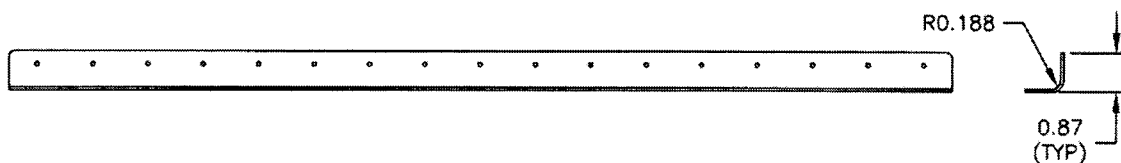
RELEASED
04.04.27

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 76469 M.C.J
11/11/15



FLAT PATTERN



D3247-1 BEND DETAIL

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Dart Aerospace Ltd

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